

Date: Thursday, 9/20/2007 3:26:41 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |                  |                |
|-----------------------|---------------------------------------|------------------|----------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : SPACER       |
| Job Number            | : 34737                               |                  |                |
| Estimate Number       | : 12953                               |                  |                |
| P.O. Number           | :                                     | Part Number      | : D32595       |
| This Issue            | : 9/20/2007 S.O. No. :                | Drawing Number   | : D3259 REV A1 |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A          |
| First Issue           | : / / Type : SMALL /MED FAB           | Drawing Revision | : A1           |
| Previous Run          | : 34253                               | Material         | :              |
| Written By            | :                                     | Due Date         | : 10/10/2007   |
| Checked & Approved By | : <u>07-09-20</u>                     | Qty:             | 10 Um: Each    |
| Comment               | : Est Rev.A New Issue 07-07-19 JLM    | Verified By:     | EC             |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S032 | 2024-T3 .032 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 1.4574 sf(s)/Unit Total : 5.8296 sf(s)

2024-T3 .032 sheet

Batch: M105555 HB 07-09-27

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3259

Dwg Rev: A1Prog Rev: A1HB 07-09-27

2-Deburr if necessary

HB 07-09-27

(10)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

HB 07-09-27

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

EN 07/10/01

(X10) counts

|     |                 |                            |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-10-02

(10)

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 9/20/2007 3:26:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 34737

Part Number: D32595

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PC 7/10/02 (12)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST174

*PC 7/10/02 (12)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07.10.03*  
*[Signature]*

Job Completion



*12 07.10.03*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                              |                |                             |
|------------------------------|----------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |                | <b>Work Order:</b> 34737    |
| <b>Description:</b> Spacer   |                | <b>Part Number:</b> D3259-5 |
| <b>Inspection Dwg:</b> D3259 | <b>Rev:</b> A1 | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 9.000             | +/-0.005      | 9.00             | *      |        |                      |          |
| 1.000             | +/-0.005      | 1.00             | *      |        |                      |          |
| 5.000             | +/-0.005      | 5.000            | *      |        |                      |          |
| 12.000            | +/-0.005      | 12.000           | *      |        |                      |          |
| 3.5000            | +/-0.005      | 3.500            | *      |        |                      |          |
| 0.875             | +/-0.005      | .875             | *      |        |                      |          |
| 0.260             | +/-0.010      | .260             | *      |        |                      |          |
| R0.50             | +/-0.030      | .50              | *      |        |                      |          |
| 0.250             | +/-0.010      | .250             | *      |        |                      |          |
| 0.875             | +/-0.005      | .875             | *      |        |                      |          |
| Ø0.098            | +0.005/-0.000 | .100             | *      |        |                      |          |
| 0.550             | +/-0.010      | .551             | *      |        |                      |          |
| R0.50             | +/-0.030      | .50              | *      |        |                      |          |
| 10.062            | +/-0.010      | 10.062           | *      |        |                      |          |
| R0.13             | +/-0.030      | .13              | *      |        |                      |          |
| 0.032 thick       | +/-0.010      | .031             | *      |        |                      |          |
| 0.130             | +/-0.010      | .130             | *      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

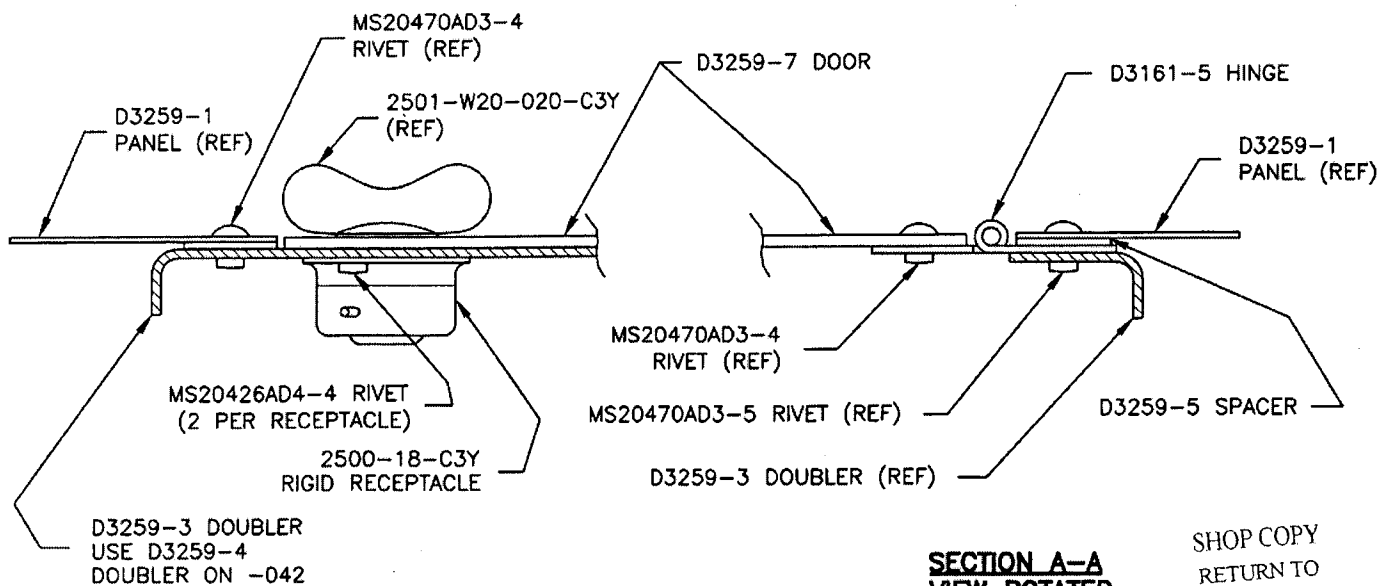
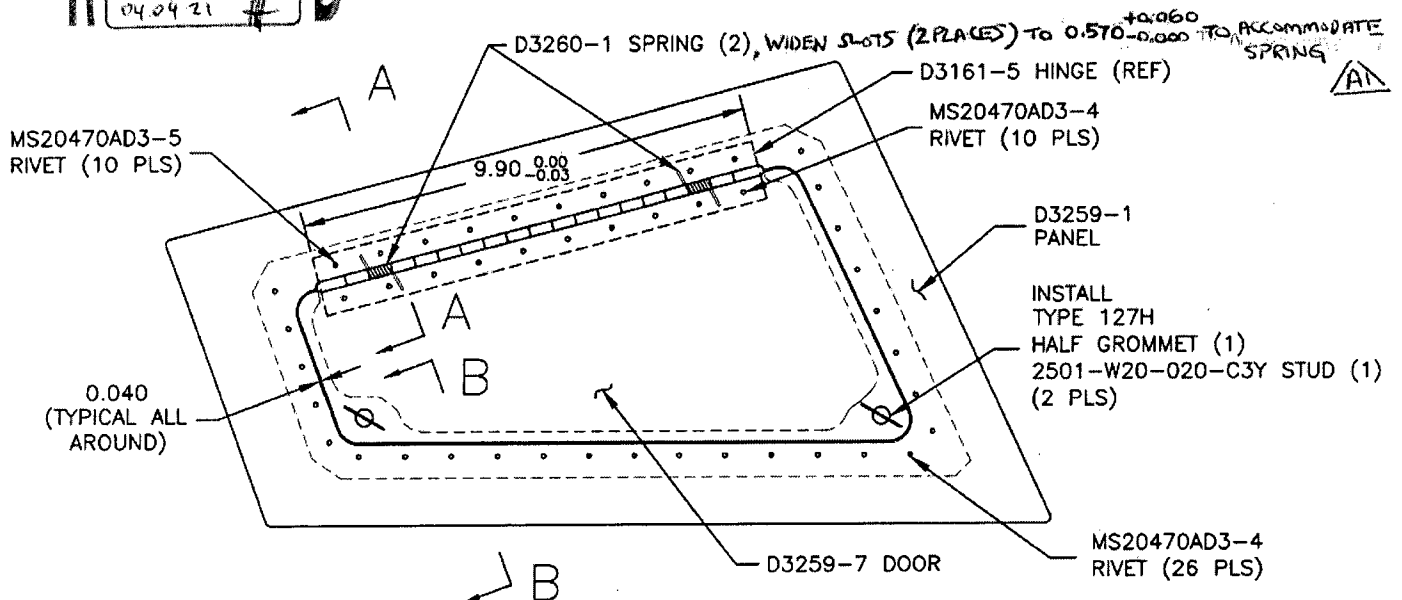
|                       |                       |                            |     |
|-----------------------|-----------------------|----------------------------|-----|
| <b>Measured by:</b> B | <b>Audited by:</b> G  | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 07-09-07 | <b>Date:</b> 07/10/01 | <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 04.08.25 | New Issue | KJ/JLM     |          |



|         |             |          |    |   |                        |
|---------|-------------|----------|----|---|------------------------|
| DESIGN  | RF          | DRAWN BY | CP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED | HP          | APPROVED | CP | DRAWING NO.<br>D3259                              | REV. A<br>SHEET 1 OF 6 |
| DATE    | 04.02.25    |          |    | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |
| A       | 04.02.25    |          |    | NEW ISSUE   |                        |
| AI      | CP 04.08.11 |          |    | WIDEN SLOTS TO ALLOW OPERATION OF SPRING          |                        |

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040421 #



SECTION B-B  
VIEW ROTATED

SECTION A-A  
VIEW ROTATED

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D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)  
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

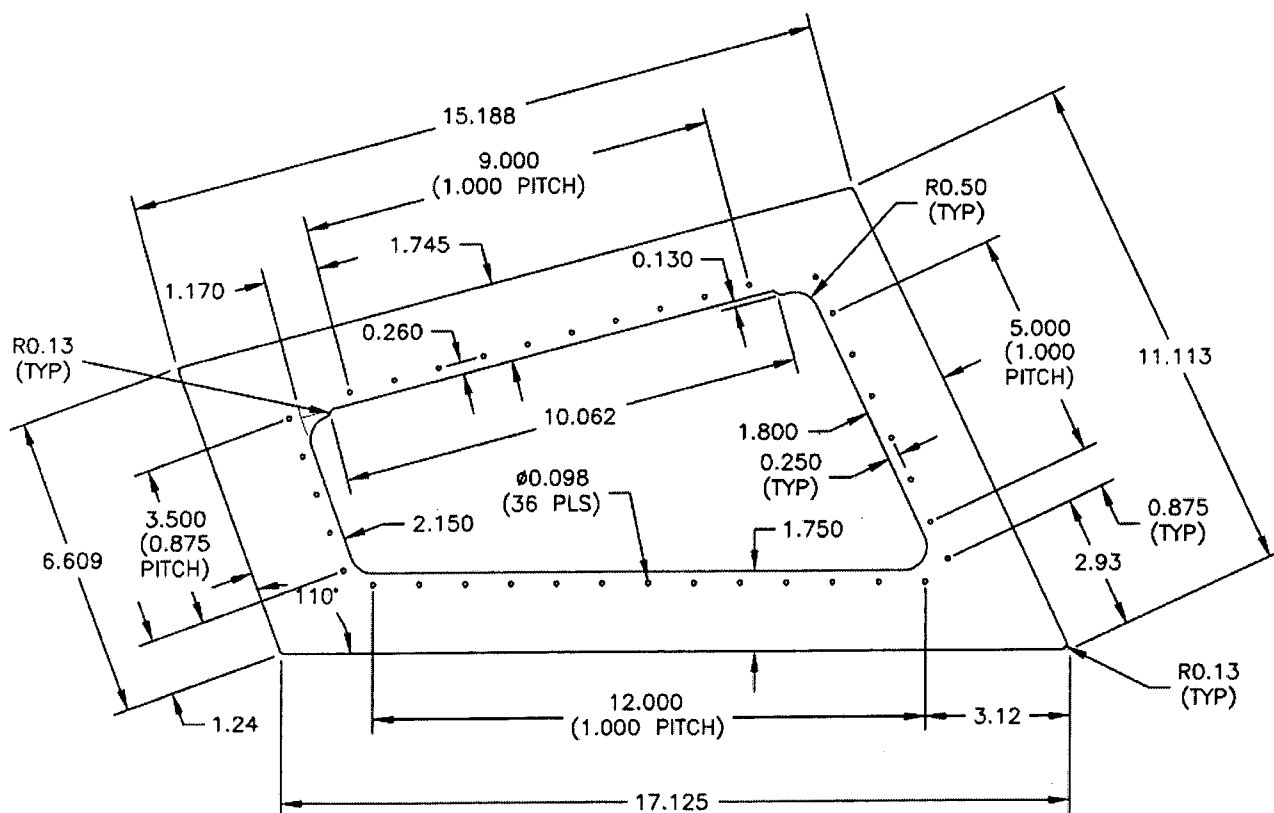
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| DATE<br>04.02.25 |                | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

RELEASED  
04.04.05



**D3259-1 PANEL**

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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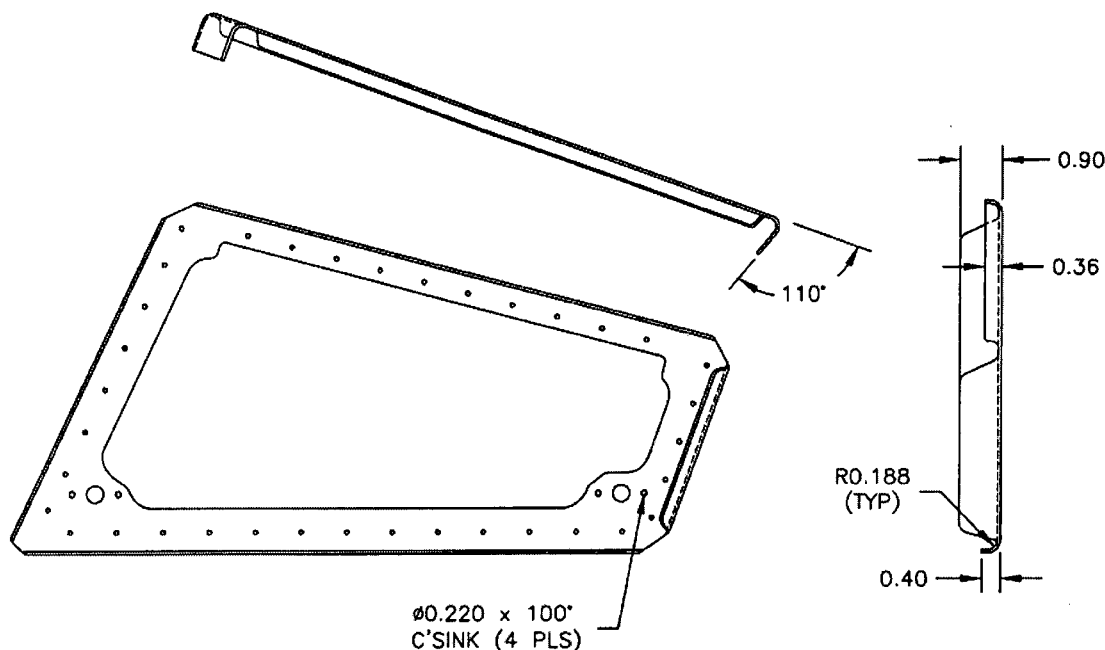
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| DATE<br>04.02.25 |               | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

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04.04.14



**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

**D3259-3/-4 NOTES:**

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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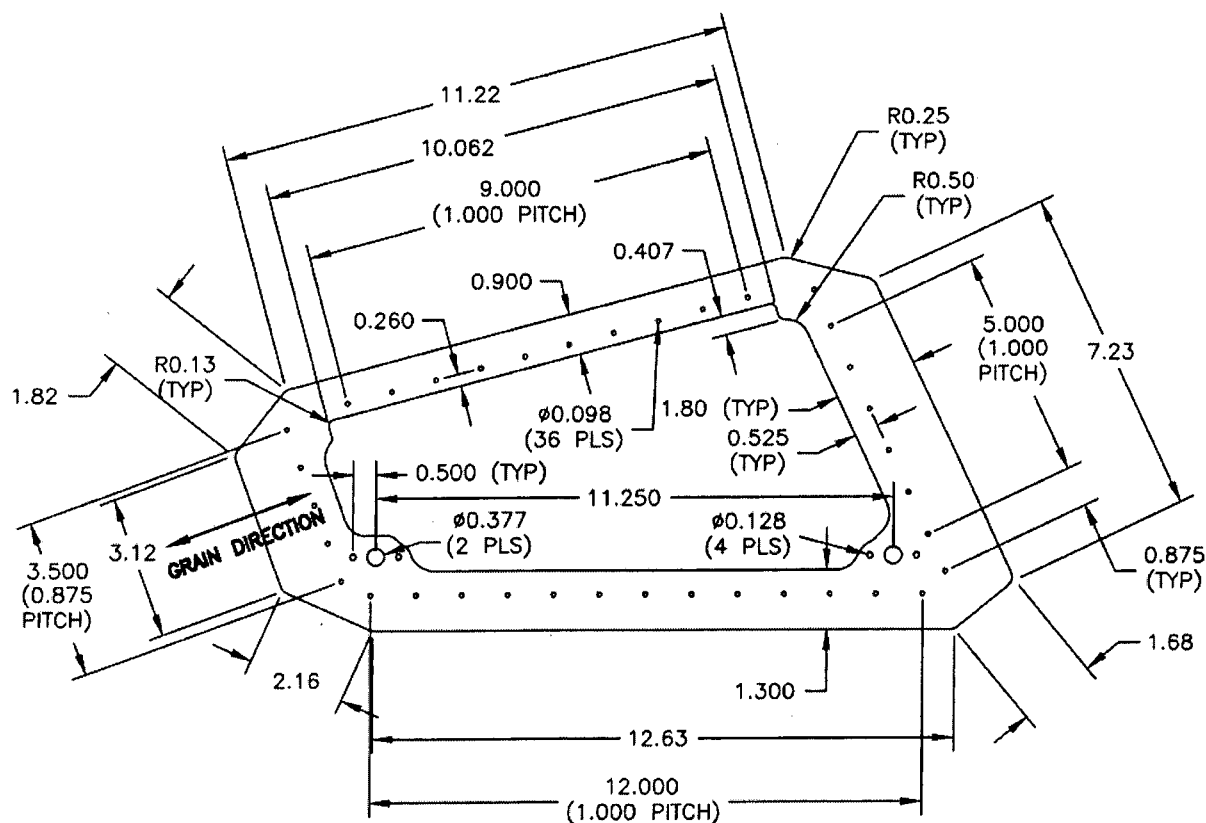
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3259                              | REV. A<br>SHEET 4 OF 6 |
| DATE<br>04.02.25              |                                | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

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04 04 14 *[Signature]*



**D3259-3/-4 DOUBLER FLAT PATTERN**  
( $\phi 0.098$  HOLES TO COINCIDE WITH HOLES IN D3259-1)

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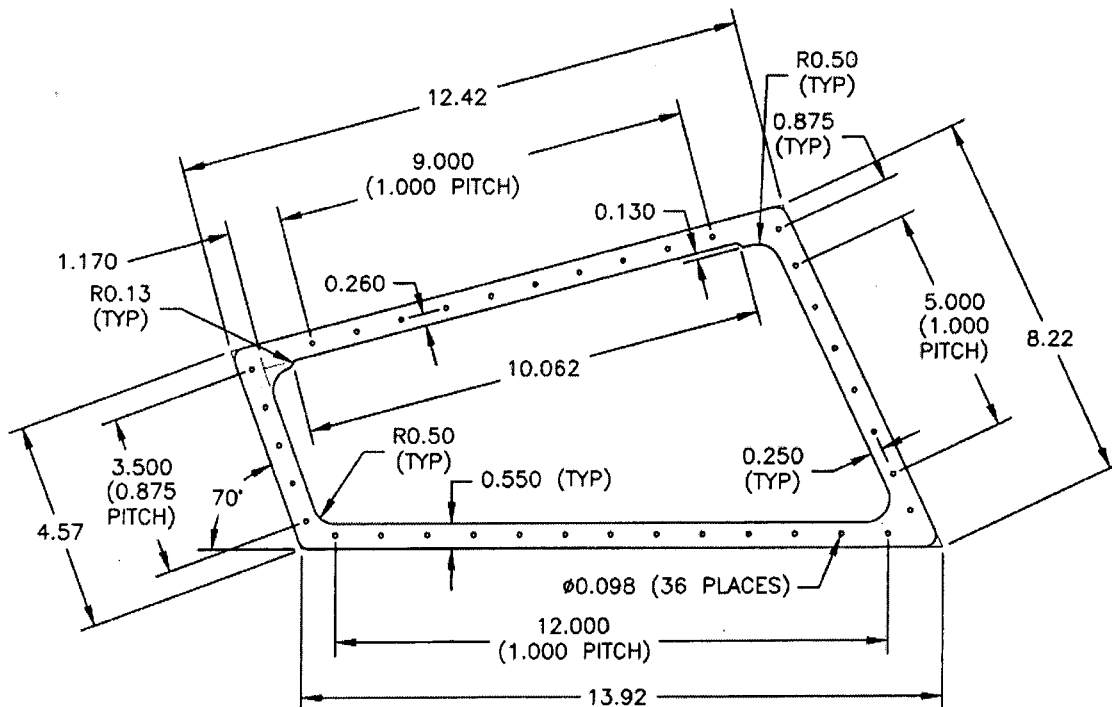
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| DATE<br>04.02.25       |                         | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

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### D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

#### NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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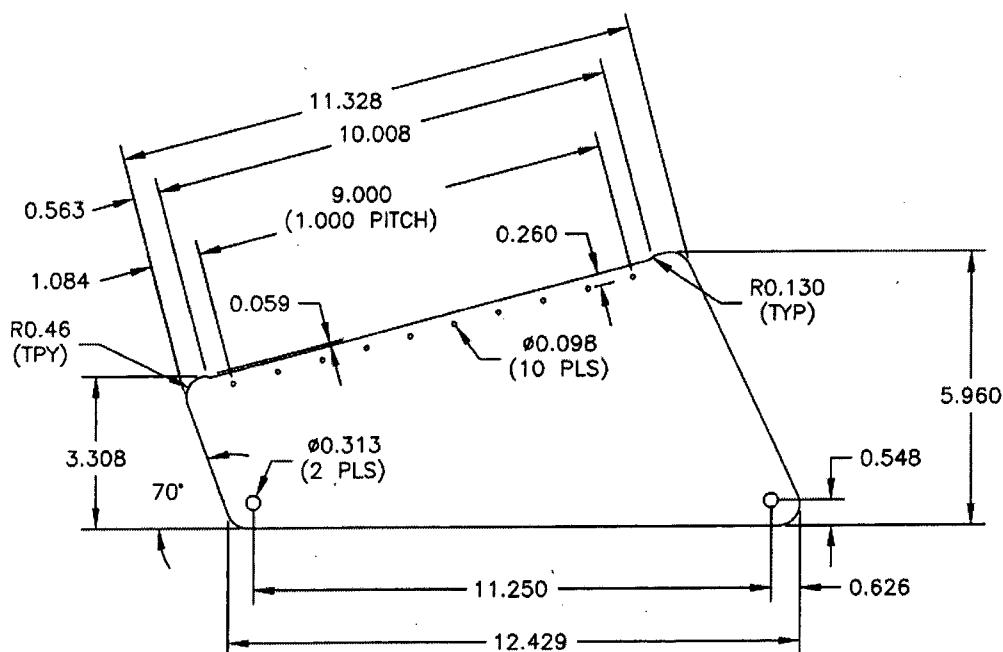
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| DATE<br>04.02.25 |              | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

RELEASED  
04.04.14



**D3259-7 DOOR**

**NOTES:**

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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